

Split

REV 5 5-14-07/17
~~PRELIMINARY ISSUE~~

Work Order ID 119764-1

119764

Page 1

May-22-14 11:30:13 AM

Item ID: D4857-043 Accept *N9000040100* Setup Start *NS1*
Revision ID: PRELIM Stop *NS2*
Item Name: Wiper Deflector Assembly, LH
Start Date: 5/22/14 Start Qty: 6.00 *6* Cust Item ID:
Required Date: 5/23/14 Req'd Qty: 6.00 *6* Customer:
Reference: rework to new REV

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4857	PD40 <u>E C</u>								
110		0.00							
110									
Small Fab	Memo	0.00							
Small Fab	Drill holes for D4857-3 as per dwg using DT10048								
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									
130		0.00							
130									
Hand Finish	Memo	0.00							
Hand Finishing	Touch up holes with primer as per dwg SEE NOTE 4 ON SHEET 6 FOR PRIMER A/R PRIMER BATCH: <u>128987</u>								

DAS
27
9-03
14/7/14

5 8F 14-07-14
S
Inspect as per
DW PD40
5 0 0 AS
14-7-14

Work Order ID 119764

119764

Page 2

May 22 14 11:30:13 AM

Item ID: D4857-043

Accept

N9000040100

Setup Start *NS1*

Revision ID: PRELJM

Stop *NS2*

Item Name: Wiper Deflector Assembly, LH

Start Date: 5/22/14 Start Qty: 6.00

6

Cust Item ID:

Required Date: 5/23/14 Req'd Qty: 6.00

6

Customer:

Reference: rework to new REV

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140

QC14- Inspect Spray Paint

0.00

140

QC

Memo

0.00

Quality Control

5
Inspect as per
DWG PP10

150

0.00

150

Small Fab

Memo

0.00

Small Fab

GLUE GASKET AS PER DWG
3M 1300/1300L ADHESIVE BATCH # ~~112087~~

POW CORING 736 # M120589

5 FF
14-07-16

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

DAS
27
5-23-14
M11/16

5
Inspect as per
DWG PP10

Work Order ID 119764

119764

Page 3

May-22-14 11:30:13 AM

Item ID: D4857-043 Accept *N900040100* Setup Start *NS1*
 Revision ID: PRELIM Stop *NS2*
 Item Name: Wiper Deflector Assembly, LH
 Start Date: 5/22/14 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 5/23/14 Req'd Qty: 6.00 *6* Customer:
 Reference: rework to new REV

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: <u>ST 2Belt</u>	0.00							
170	Packaging Memo	0.00				5X		14-7-18	DAS 26 9-89
180	QC21- Final Inspection - Work Order Release	0.00							
180	QC Memo	0.00							
	Quality Control								

POSITIVE RECALL

EFFECTIVE 11/05/22 AUTH
 RELEASED 8 DATE 11/07/17

DAS 27 9-89

M/H/16

Release Dwg as
 Rsk Rev E

May-22-14 11:30:13 AM

Work Order ID: 119764

119764

Parent Item: D4857-043

D4857-043

Parent Item Name: Wiper Deflector Assembly, LH

Start Date: 5/22/14

Required Date: 5/23/14

Start Qty: 6.00

Required Qty: 6.00

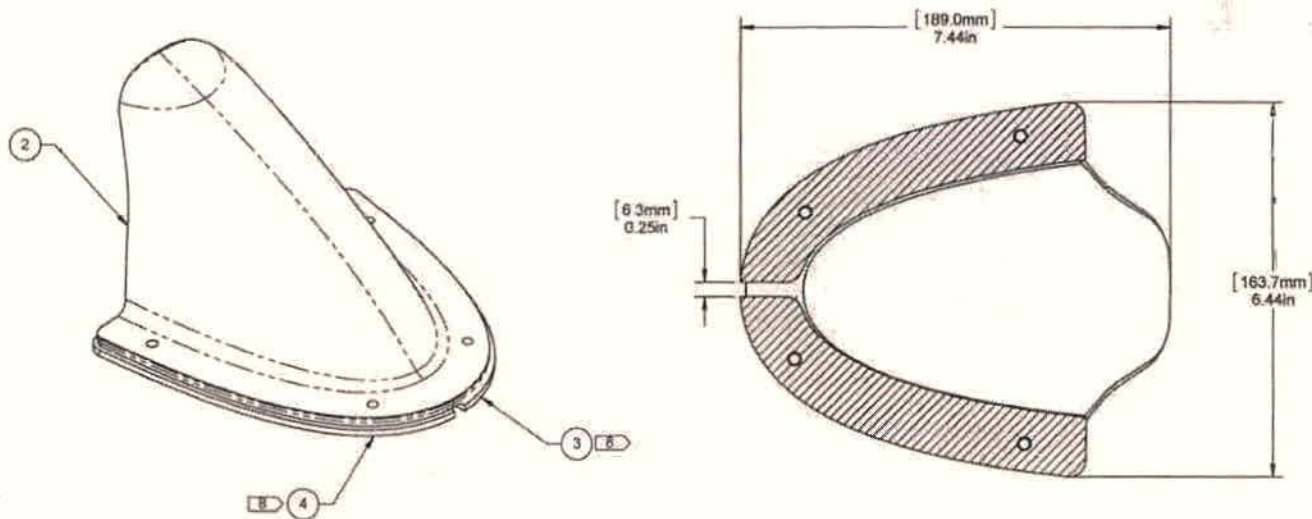
Comments: IPP REV:A 14.05.21 REV.PD10 DD VERF:JLM

[illegible]

PRELIMINARY ISSUE

PRELIMINARY ISSUE

ITEM	QTY	P/N	DESCRIPTION
1	X	D4857-043	WIPER DEFLECTOR ASSEMBLY, LH
2	1	D4857-3	WIPER DEFLECTOR LH
3	1	D5117-1	GASKET
4	1	D5117-3	GASKET



D4857-043 WIPER DEFLECTOR ASSEMBLY, LH

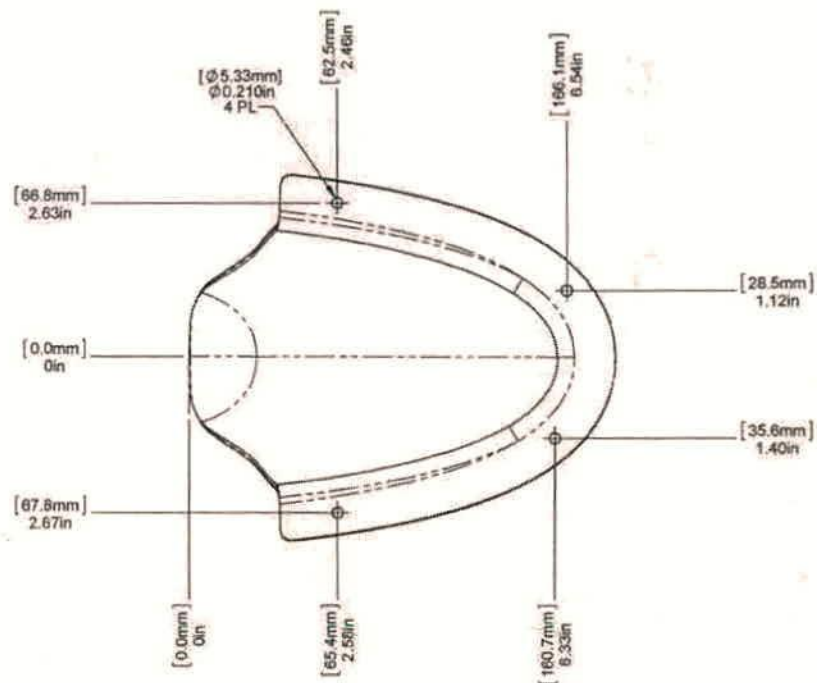
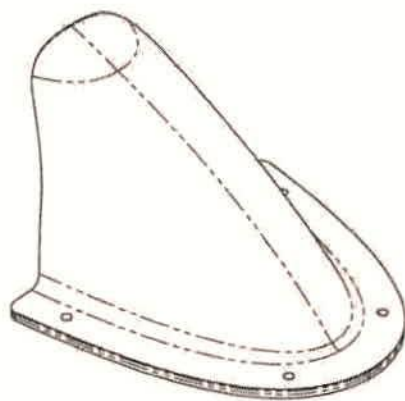
NOTES

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED, ALL METRIC DIMENSIONS ARE REFERENCE DIMENSIONS.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D4857-043, AGUSTA P/N "TBD". REVISION AND BATCH NUMBER AS PER QSI 044 METHOD 6.1
- 7) WEIGHT: 0.38 lbs (0.17 kg)
- 8) BOND D5117-1/3 GASKET TO EDGE OF PART USING 3M 1300/1300L ADHESIVE

Don Corney

WORK IN PROGRESS

REV.	DESCRIPTION	BY	DATE
D	ADDED D4857-043 (ZN C7-1), D4857-044 (ZN C7-2), D4857-3 (ZN C7-4), D4857-4 (ZN C7-5) AND D4857-M (ZN C7-6)	AK	14.05.13
C	ADDED 4 MOUNTING HOLES	DW	13.12.09
B	REVISED BOM, DRAWING VIEWS, NOTES	PS	13.06.13
A	NEW RELEASE	DB	13.05.23
DESIGN	DW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AK		
CHECKED		DRAWING NO.	REV. D
MFG APPR.		D4857	SHEET 1 OF 7
APPROVED		TITLE	SCALE
DE APPR.	DS	WIPER DEFLECTOR	NTS
DATE	14.05.13	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED, UNLESS OTHERWISE NOTED. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	



D4857-3 WIPER DEFLECTOR, LH

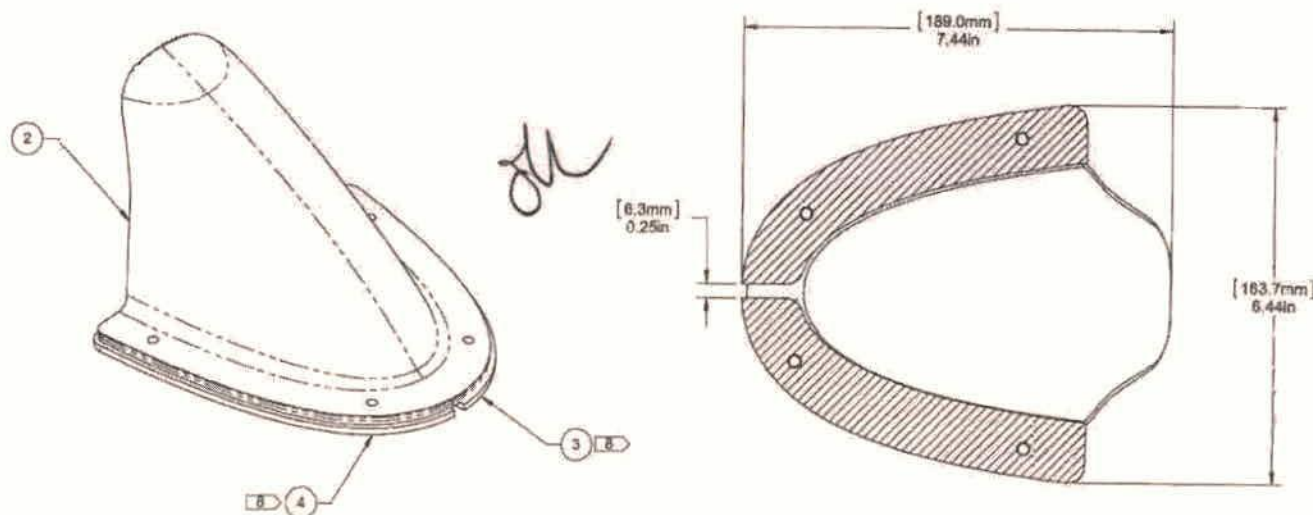
NOTES:

- 1) MATERIAL: MADE FROM D4857-M
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED, ALL METRIC DIMENSIONS ARE REFERENCE DIMENSIONS.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.24 lbs (0.11 kg)
- 8) PART DIMENSIONS CONTROLLED BY CAD MODEL FILE D4857-3-d.IGES

WORK IN PROGRESS

DESIGN	DW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AK		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4857	SHEET 4 OF 7
APPROVED		TITLE	SCALE
DE APPR.	DS	WIPER DEFLECTOR	NTB
DATE	14.05.13	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS AVAILABLE ON THE OPEN SOURCE CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	

ITEM	QTY	P/N	DESCRIPTION
1	X	D4857-043	WIPER DEFLECTOR ASSEMBLY, LH
2	1	D4857-3	WIPER DEFLECTOR LH
3	1	D5117-1	GASKET
4	1	D5117-3	GASKET



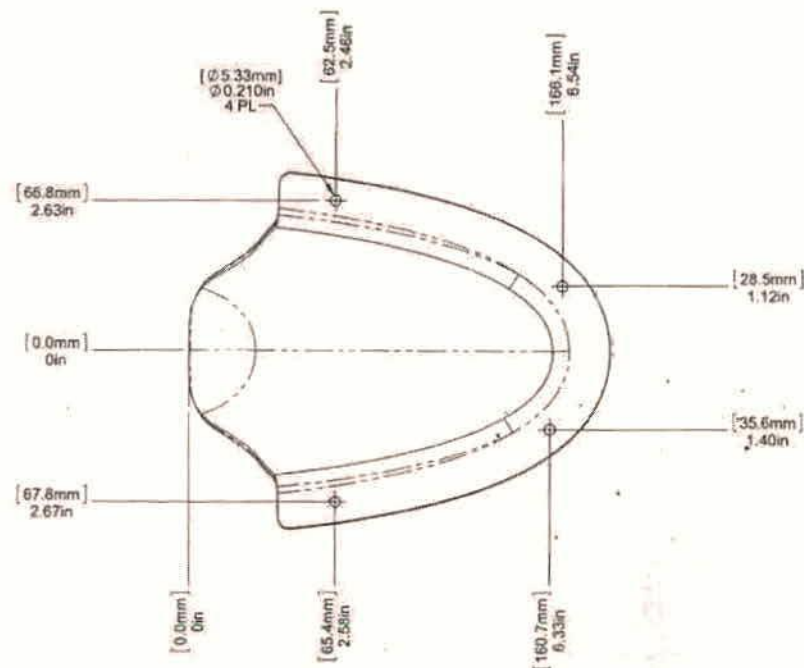
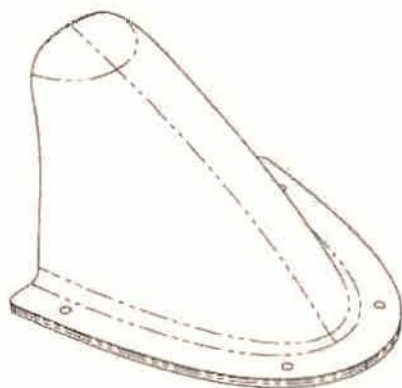
D4857-043 WIPER DEFLECTOR ASSEMBLY, LH

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 011 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED, ALL METRIC DIMENSIONS ARE REFERENCE DIMENSIONS.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D4857-043, REVISION, BATCH NUMBER, AND DATE OF MANUFACTURE, AS PER QSI 044 METHOD 6.1
- 7) WEIGHT: 0.38 lbs (0.17 kg)
- 8) BOND D5117-1/3 GASKET TO EDGE OF PART USING DOW CORNING 736 ADHESIVE

E	REVISE NOTE 6 (ZN AS-1, AS-2, AS-3); AND NOTE 8 (ZN AS-1, AS-2, AS-3)	AK	14.06.05
D	ADDED D4857-043 (ZN C7-1), D4857-044 (ZN C7-2), D4857-3 (ZN C7-4), D4857-4 (ZN C7-5) AND D4857-M (ZN C7-6)	AK	14.05.13
C	ADDED 4 MOUNTING HOLES	DW	13.12.08
B	REVISED BOM, DRAWING VIEWS, NOTES	PB	13.08.13
A	NEW RELEASE	DB	13.05.29
REV.	DESCRIPTION	BY	DATE
DESIGN	DW	DART AEROSPACE LTD HAMMERSBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV: E
MFG. APPR.	JFS	D4857	SHEET 1 OF 7
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	WIPER DEFLECTOR	NT3
DATE	14.06.05	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD. THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED TO THE CUSTOMER UNDER THE NAME TO BE USED FOR THE PRODUCT. THE CUSTOMER IS NOT TO BE USED FOR THE PRODUCT WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>	

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D4857-3 WIPER DEFLECTOR, LH

RELEASED
2014-06-11

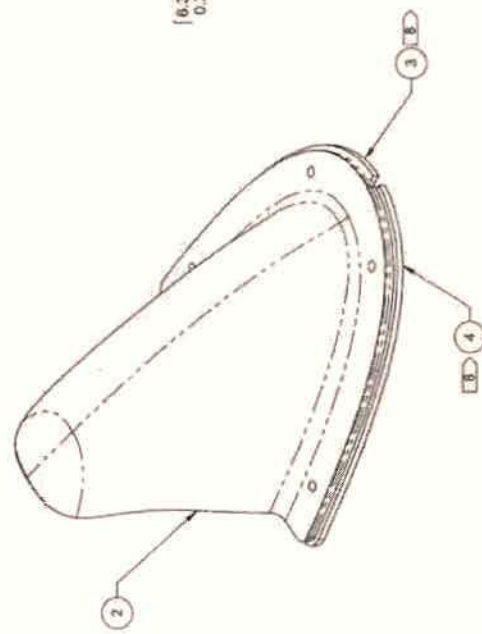
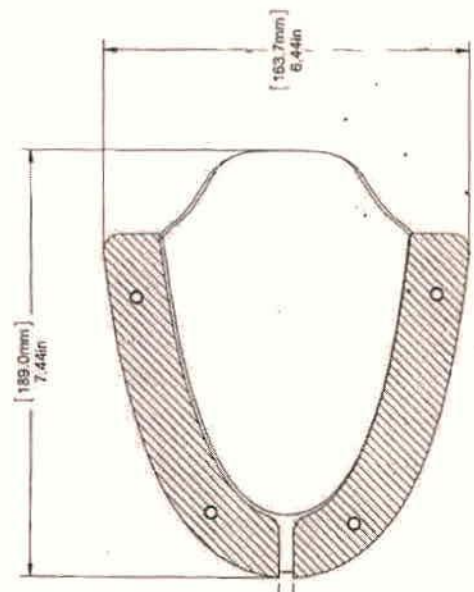
NOTES:

- 1) MATERIAL: MADE FROM D4857-M
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 318 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED, ALL METRIC DIMENSIONS ARE REFERENCE DIMENSIONS.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 6.24 lbs (0.11 kg)
- 8) PART DIMENSIONS CONTROLLED BY CAD MODEL FILE D4857-3-e.IGES

APPROVED

DESIGN	DW	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VS	DRAWING NO.	REV. E
MFG. APPR.	JFS	D4857	SHEET 4 OF 7
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	WIPER DEFLECTOR	NTS
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ITEM	QTY	PIN	DESCRIPTION
1	X	D4857-043	WIPER DEFLECTOR ASSEMBLY, LH
2	1	D4857-3	WIPER DEFLECTOR, LH
3	1	D5117-1	GASKET
4	1	D5117-3	GASKET



D4857-043 WIPER DEFLECTOR ASSEMBLY, LH

RELEASED
R 2014-06-11

E	REVISE NOTE 6) (ZN AS-1, AS-2, AS-3), AND NOTE 8) (ZN AS-1, AS-2, AS-3)	AK	14.06.05
D	ADDED D4857-043 (ZN C7-3), D4857-044 (ZN C7-3), D4857-3 (ZN C7-4), D4857-4 (ZN C7-6) AND D4857-M (ZN C7-5)	AK	14.06.13
C	ADDED 4 MOUNTING HOLES	DW	13.02.06
B	REVISED BOM, DRAWING VIEWS, NOTES	DB	13.03.13
A	NEW RELEASE	DB	13.08.23
REV	DESCRIPTION	BY	DATE
DESIGN	DW		
DRAWN	RF		
CHECKED	VS		
MFG. APPR.	JFS		
APPROVED	MP		
DE APPR.	DS		
DATE	14.06.05		

NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED, ALL METRIC DIMENSIONS ARE REFERENCE DIMENSIONS.
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART PIN D4857-043, REVISION, BATCH NUMBER, AND DATE OF MANUFACTURE, AS PER QSI 044 METHOD 6.1
7) WEIGHT: 0.38 lbs (0.17 kg)
8) BOND D5117-1:3 GASKET TO EDGE OF PART USING DOW CORNING 736 ADHESIVE

APPROVED	DATE	14.06.05	1
			2
			3
			4
			5
			6
			7
			8

APPROVED

DESIGN	DW		
DRAWN	RF		
CHECKED	VS		
MFG. APPR.	JFS		
APPROVED	MP		
DE APPR.	DS		
DATE	14.06.05		

APPROVED

DESIGN	DW		
DRAWN	RF		
CHECKED	VS		
MFG. APPR.	JFS		
APPROVED	MP		
DE APPR.	DS		
DATE	14.06.05		

APPROVED

DESIGN	DW		
DRAWN	RF		
CHECKED	VS		
MFG. APPR.	JFS		
APPROVED	MP		
DE APPR.	DS		
DATE	14.06.05		

APPROVED

DESIGN	DW		
DRAWN	RF		
CHECKED	VS		
MFG. APPR.	JFS		
APPROVED	MP		
DE APPR.	DS		
DATE	14.06.05		

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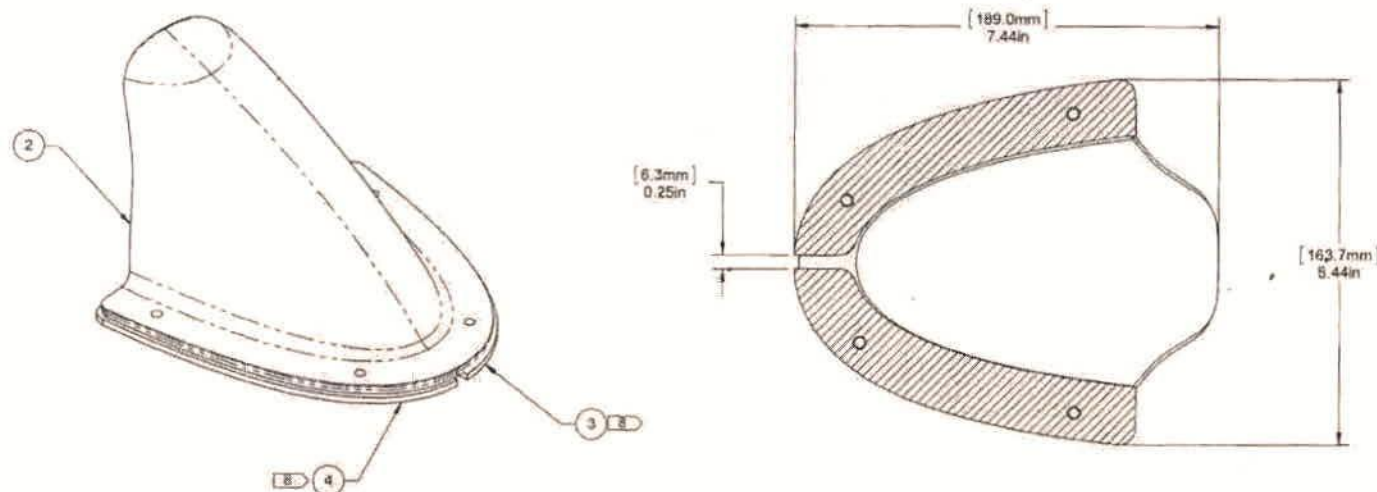
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MFG. APPR.	JFS		
APPROVED	MP		
DE APPR.	DS		
DATE	14.06.05		

APPROVED

DESIGN	DW		
DRAWN	RF		
CHECKED	VS		
MFG. APPR.	JFS		
APPROVED	MP		
DE APPR.	DS		
DATE	14.06.05		

APPROVED

ITEM	QTY -044	P/N	DESCRIPTION
1	X	D4857-044	WIPER DEFLECTOR ASSEMBLY, RH
2	1	D4857-4	WIPER DEFLECTOR RH
3	1	DS117-6	GASKET
4	1	DS117-7	GASKET



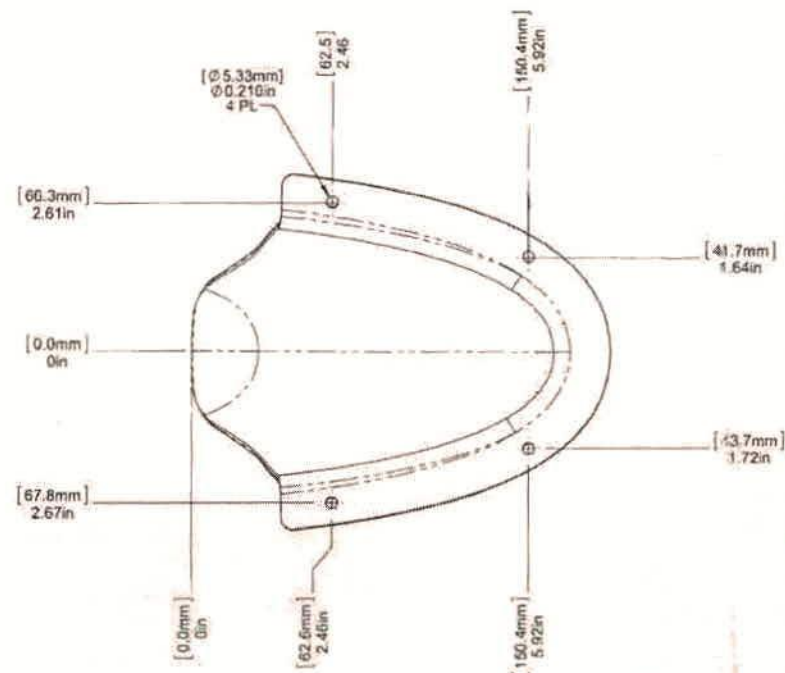
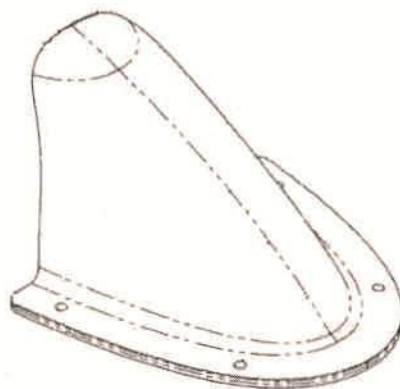
D4857-044 WIPER DEFLECTOR ASSEMBLY, RH

RELEASED
2014-06-11

NOTES

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 016 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED, ALL METRIC DIMENSIONS ARE REFERENCE DIMENSIONS.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D4857-044, REVISION, BATCH NUMBER, AND DATE OF MANUFACTURE, AS PER QSI 044 METHOD 6.1
- 7) WEIGHT: 0.38 lbs (0.17 kg)
- 8) BOND DS117-5/-7 GASKET TO EDGE OF PART USING DOW CORNING 736 ADHESIVE

APPROVED	DESIGN	DW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	RF		
	CHECKED	VS	DRAWING NO. D4857	REV. E
	MFG. APPR.	JFS	SHEET 2 OF 2	
	APPROVED	MP	TITLE WIPER DEFLECTOR	SCALE
	DE APPR.	DS	NTS	
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D4857-1 WIPER DEFLECTOR

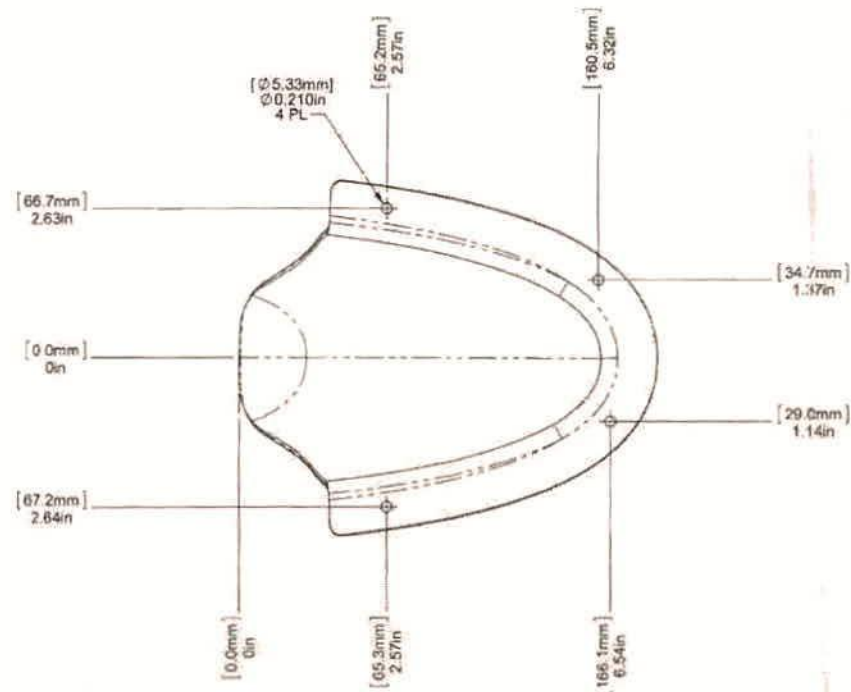
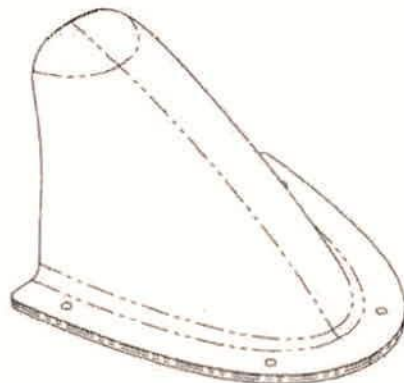
RELEASED
2014-06-11

NOTES:

- 1) MATERIAL: MADE FROM D4857-M
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED, ALL METRIC DIMENSIONS ARE REFERENCE DIMENSIONS.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D4857-1, REVISION, BATCH NUMBER, AND DATE OF MANUFACTURE, AS PER QSI 044 METHOD 6.1
- 7) WEIGHT: 0.24 lbs (0.11 kg)
- 8) PART DIMENSIONS CONTROLLED BY CAD MODEL FILE D4857-1.e.IGES

APPROVED

DESIGN	DW	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VS	DRAWING NO.	REV. E
MFG. APPR.	JFS	D4857	SHEET 3 OF 7
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	WIPER DEFLECTOR	NTS
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D4857-4 WIPER DEFLECTOR, RH

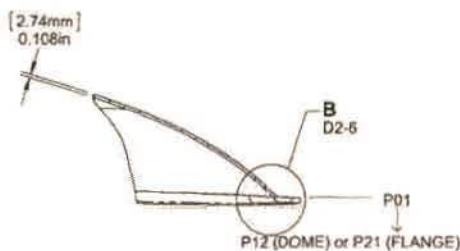
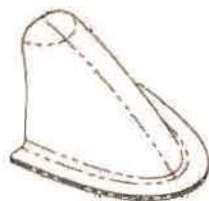
RELEASED
2014-06-11

NOTES:

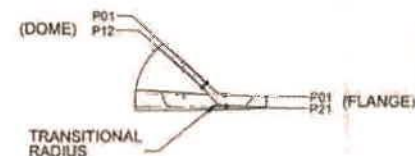
- 1) MATERIAL: MADE FROM D4857-M
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI D18 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED, ALL METRIC DIMENSIONS ARE REFERENCE DIMENSIONS.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.24 lbs (0.11 kg)
- 8) PART DIMENSIONS CONTROLLED BY CAD MODEL FILE D4857-4.e.IGES

APPROVED

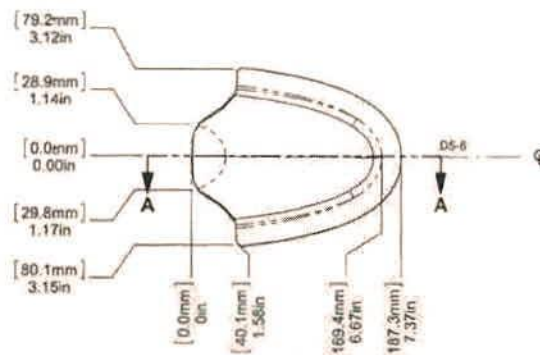
DESIGN	DW	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VS	DRAWING NO. D4857	REV. E
MFG. APPR.	JFS		SHEET 5 OF 7
APPROVED	MP	TITLE WIPER DEFLECTOR	SCALE
DE APPR.	DS		NTS
DATE	14.06.05	COPYRIGHT © 2013 BY DART AEROSPACE LTD	



SECTION A-A
DS-6



DETAIL B
DS-6



D4857-M WIPER DEFLECTOR

NOTES:

- 1) MATERIAL: KEVLAR #265/353 4H SATIN, EPOXY PREPREG, 250°F CURE, 40% R/C
- 2) MATERIAL: CARBON FIBER PREPREG, ALDILA PREPREG SYSTEM 3K2X2-FR250-204/40 T300.
- 3) MATERIAL: ALDILA #120 E-GLASS AR250 WITH 48% RC.
- 4) FINISH: PRIMER IAW MIL-P-85582, 2-7 MIL MAX.
- 5) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 6) UNITS: INCHES UNLESS OTHERWISE NOTED, ALL METRIC DIMENSIONS ARE REFERENCE DIMENSIONS.
- 7) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 8) IDENTIFICATION: N/A
- 9) WEIGHT: 0.24 lbs (0.11 kg)
- 10) PART DIMENSIONS CONTROLLED BY CAD MODEL FILE D4857-M-e.JGES
- 11) SEE PAGE 7 FOR LAYUP SCHEDULE, MANUFACTURE IAW MPP 145, CURE 250°F FOR 4 HOURS.

RELEASED
2014-06-11

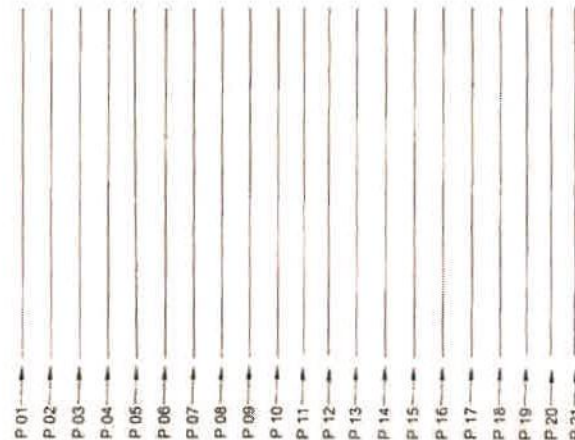
APPROVED

DESIGN	DW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	RTV, E
MFG. APPR.	JFS	D4857	SHEET 6 OF 7
APPROVED	MP	TITLE	WIPER DEFLECTOR
DE APPR.	DS	NTS	
DATE	14.06.05	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS NOT TO BE RELEASED OUTSIDE THE DART AEROSPACE LTD OR ITS SUBSIDIARIES WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	



LAYUP OF LAYERS (DOME)

LAMINATE - .108in (12 LAYERS)			
PLY	WARP ANGLE	MATERIAL	THICKNESS
01	90	①	.008-.010
02	0	①	.008-.010
03	90	②	.008-.010
04	0	②	.008-.010
05	90	②	.008-.010
06	0	②	.008-.010
07	90	②	.008-.010
08	0	②	.008-.010
09	90	②	.008-.010
10	0	②	.008-.010
11	90	③	.008-.010
12	0	③	.008-.010



LAYUP OF LAYERS (FLANGE)

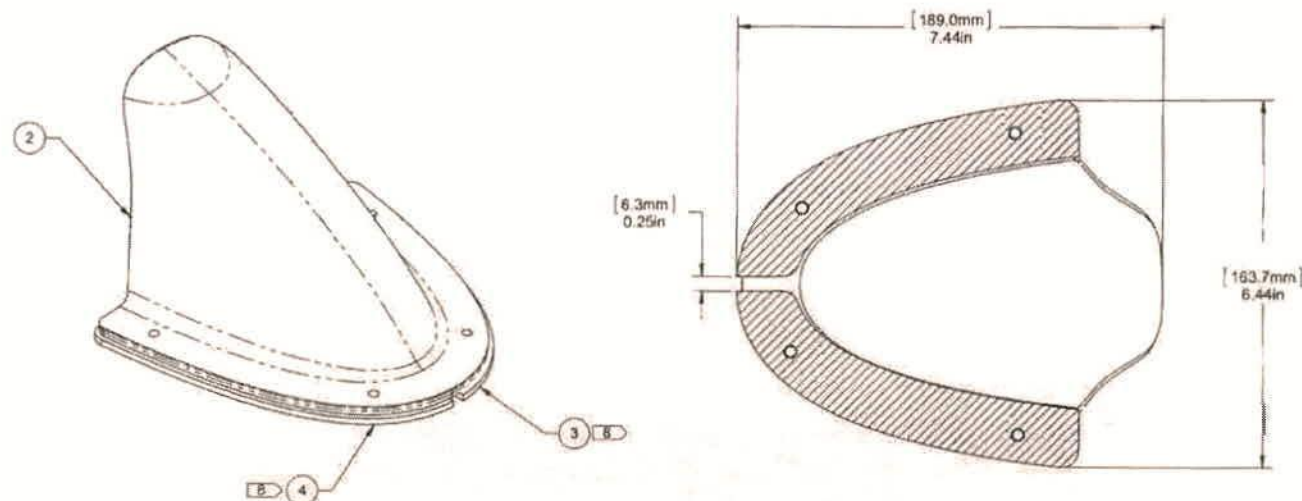
LAMINATE - .189in (21 LAYERS)			
PLY	WARP ANGLE	MATERIAL	THICKNESS
01	90	①	.008-.010
02	0	①	.008-.010
03	90	②	.008-.010
04	0	②	.008-.010
05	90	②	.008-.010
06	0	②	.008-.010
07	90	②	.008-.010
08	0	②	.008-.010
09	90	②	.008-.010
10	0	②	.008-.010
11	90	②	.008-.010
12	0	②	.008-.010
13	90	②	.008-.010
14	0	②	.008-.010
15	90	②	.008-.010
16	0	②	.008-.010
17	90	②	.008-.010
18	0	②	.008-.010
19	90	②	.008-.010
20	0	②	.008-.010
21	90	③	.005

RELEASED
2014-06-11

APPROVED

DESIGN	DW	DART AEROSPACE LTD HAERKESSBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO. D4857	REV. E
MFG. APPR.	JFS	TITLE WIPER DEFLECTOR	SHEET 7 OF 7
APPROVED	MP		SCALE NTS
DE APPR.	DS	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND IS SUPPLIED ON CONFIDENTIALITY. IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE LTD.	
DATE	14.06.05		

ITEM	QTY -043	P/N	DESCRIPTION
1	X	D4857-043	WIPER DEFLECTOR ASSEMBLY, LH
2	1	D4857-3	WIPER DEFLECTOR LH
3	1	D5117-1	GASKET
4	1	D5117-3	GASKET



D4857-043 WIPER DEFLECTOR ASSEMBLY, LH

RELEASED
2014-06-11

NOTES

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED, ALL METRIC DIMENSIONS ARE REFERENCE DIMENSIONS.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D4857-043, REVISION, BATCH NUMBER, AND DATE OF MANUFACTURE, AS PER QSI 044 METHOD 6.1
- 7) WEIGHT: 0.38 lbs (0.17 kg)
- 8) BOND D5117-1/3 GASKET TO EDGE OF PART USING DOW CORNING 736 ADHESIVE

REV.	DESCRIPTION	BY	DATE
E	REVISE NOTE 6) (ZN A5-1, A5-2, A5-3); AND NOTE 8) (ZN A5-1, A5-2, A5-3)	AK	14.06.05
D	ADDED D4857-043 (ZN C7-1), D4857-044 (ZN C7-2), D4857-3 (ZN C7-4), D4857-4 (ZN C7-5) AND D4857-M (ZN C7-6)	AK	14.05.13
C	ADDED 4 MOUNTING HOLES	DW	13.12.09
B	REVISED BOM, DRAWING VIEWS, NOTES	PB	13.08.13
A	NEW RELEASE	DB	13.05.23
DESIGN	DW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4857 REV. E SHEET 1 OF 1 TITLE WIPER DEFLECTOR SCALE NTS <small>COPYRIGHT © 2013 BY DART AEROSPACE LTD This document is the property of Dart Aerospace Ltd and is supplied on the condition that it is not to be used for any purpose other than that for which it was originally intended without the written permission of Dart Aerospace Ltd.</small>	
DRAWN	RF		
CHECKED	VS		
MFG. APPR.	JFS		
APPROVED	MP		
DE APPR.	DS	DATE 14.06.05	

APPROVED

Work Order ID 122239

July 14-14 1:39:01 PM

122239

Page 1

Item ID: D5117-1 Accept ***N9000040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Gasket
 Start Date: 7/14/14 Start Qty: 5.00 ***5*** Cust Item ID: ID Per 6.7
 Required Date: 7/14/14 Req'd Qty: 5.00 ***5*** Customer: weight 0.07lbs.
 Reference:

Approvals: Process Plan: MLJ Date: 140714 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5117	A								
100		0.00							
100									
Small Fab	Memo	0.00							
Small Fab	1-CUT GASKET USING DT10051								
	2-PUNCH HOLES USING DT10052								
110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	Identify as per dwg & Stock Location: <u>G.A.</u>	0.00							
120									
Packaging	Memo	0.00							
Packaging									

5 FF 14-07-14
S
5 FF 14-07-15

Shp
14-11-15

Work Order ID 122239

122239

Page 2

July-14-14 1:39:01 PM

Item ID: D5117-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Gasket

Stop *NS2*

Start Date: 7/14/14 Start Qty: 5.00 *5*

Cust Item ID:

Required Date: 7/14/14 Req'd Qty: 5.00 *5*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130	QC21- Final Inspection - Work Order Release -	0.00							
-----	---	------	--	--	--	--	--	--	--

130

QC

Memo

0.00

Quality Control

MLD 14-07-16
4-7-15

Picklist Print

July-14-14 1:39:04 PM

Page 1

Work Order ID: 122239

122239

Parent Item: D5117-1

D5117-1

Parent Item Name: Gasket

Start Date: 7/14/14

Required Date: 7/14/14

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A NEW ISSUE 14-05-22 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
8623K338		Purchased		No			sf	20.0000		1			
8623K338									**	FF 14-07-14			
Silicon Rubber 1/8" (SOFT)													

Location

Loc Qty

Loc Code

MAT052

20

127443

20

1

Work Order ID 122240

July-14-14 1:39:13 PM

122240

Page 1

Item ID: D5117-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Gasket
 Start Date: 7/14/14 Start Qty: 5.00 ***5*** Cust Item ID:
 Required Date: 7/14/14 Req'd Qty: 5.00 ***5*** Customer:
 Reference:

Approvals: Process Plan: MCS Date: 14-07-14 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5117	A								
100		0.00							
100									
Small Fab	Memo	0.00							
Small Fab	1-CUT GASKET USING DT10051								
	2-PUNCH HOLES USING DT10052								
110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	Identify as per dwg & Stock Location: <u>E.A.</u>	0.00							
120									
Packaging	Memo	0.00							
Packaging									

5 FF 14-07-14
S
5 FF 14-07-15

SW
4715

Work Order ID 122240

July-14-14 1:39:13 PM

122240

Page 2

Item ID: D5117-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Gasket

Stop *NS2*

Start Date: 7/14/14 Start Qty: 5.00

5

Cust Item ID:

Required Date: 7/14/14 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

MLJ 14-07-16

7-15

Picklist Print

July-14-14 1:39:16 PM

Page 1

Work Order ID: 122240

122240

Parent Item: D5117-3

D5117-3

Parent Item Name: Gasket

Start Date: 7/14/14

Required Date: 7/14/14

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A NEW ISSUE 14-05-22 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
8623K338		Purchased	No				sf	20.0000		1			

8623K338

Silicon Rubber 1/8" (SOFT)

**

FF 14-07-14

Location

Loc Qty

Loc Code

MAT052

20

127443

20

1